

Date: Thursday, 20/11/2008 3:32:40 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 43586	
Estimate Number : 10123	
P.O. Number :	Part Number : D2060
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D2060 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 30160	Material :
Written By :	Due Date : 20/12/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JUD 08.11.21</u>	
Comment : Est: A 98.12.09 New Issue DM/KS	

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 PG PURCHASING

**Comment:** PURCHASINGIssue P/O: 7655

Make per Dwg D2060

Possible Supplier: Sieg's Manufacturing

Material release note required

C20811124

(20)

2.0 D2060P Aspirator



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
 ASPIRATOR

3.0 PACKAGING 1 PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C 8/14/11 (20)

4.0 QC6 DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

S 03 12/12 center (20)

5.0 PACKAGING 1 PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: 166

8/12/12

(20x)

sd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:32:40 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 43586

Part Number: D2060

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/15 HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.00 O'DIA

2.10 I'DIA

4.125

.84

1.312 I'DIA



MAT'L :
.063 THICK
1100 ALUMINUM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. 45588

REVISION		RIVET CODE SHALL BE PER NAS 623		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
DRAWN		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COM'D OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		CONTRACT NO.		DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED		BASIC CODE		DRAWN		DATE		
DESCRIPTION OF CHANGE		D-DIMPLE DIGIT-NO OF SHEETS C-COUNTERSINK		DESK		1492		
		LIMITS		LENGTH DASH NO.		TITLE		
		1 TOLERANCES - .001 MAX 2 ANGLES 3 PARALLELISM 4 ECCENTRICITY 5 SYMMETRY ABOUT ALL H/C CENTRE LINES .005		BASIC CODES		ASPIRATOR CORE		
		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 / 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER UNF - 5 - 7742 5. HOLES PER AND 10387		8J-MS20470AD 8B-MS20428AD		DWC NO YSD 2060		
		REPORT ALL DISCREPANCIES - DO NOT SCALE		CLIENT		SCALE 1:1 SHT 1 OF 1		

YSD 2060

A

2

1



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: 12/10/08

Customer: Dart Aerospace

Packing Slip: 36124

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2000109S	10	14G	✓	✓	✓
D2000111S	10	14G.	✓	✓	✓
D2060S	20	14G	✓	✓	✓
D2061P	20	14G	n/a	✓	✓

Notes:

PO# 7655

12/12/11

Material Certification Attached: Yes ~~no~~

02/12/12

UTM. GERRY



ALCOA WITH PRODUCTS
1480 Manheim Pike
Lancaster Pa 17601

Certification of Test Results

P/N 970200

PO 380880

SOLD TO

SHIP TO

CERT NO 3000675996
DATE 4/23/2007
SKID NO 661033
SKID WGT 9,885
PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756				MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO					
ALLOY	1100	TEMPER	0	FORM	COIL		
GAUGE	06300	WIDTH	48.0000	LENGTH	0.0000		

LOT: 114171 COIL: B01 DROP: 07T0187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
*U718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 C, AMS 4001H 1100 O,
ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O
PAX CERTS: 714-736-4840

** END OF CERTIFICATION **

08/10/12

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our products. Certification of test results shall not be reproduced except in full.

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Authorized By:

JEFF KREADY, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 380880 Part: Order No.: 376276
TR clerk signature: *C. Kready*